

Date: Thursday, 27/11/2008 2:25:56 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: TOP PANEL ASS'Y		
Job Number	: 43820		Part Number	: D365011		
Estimate Number	: 13135		Drawing Number	: D3650 REV.C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 27/11/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 20/12/2008		
Previous Run	: 40694		Qty:	6 Um: Each		
Written By	:					
Checked & Approved By	: <u>JUL 08-11-27</u>					
Comment	: Est Rev:B ECN 1113P 08-01-22 DD					
	Est Rev:C ecn1162 08-04-02 DD verified by: EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S26GA	304/316 0.018 SHEET	
		Comment: Qty.: 0.0193 sf(s)/Unit Total : 0.1159 sf(s) 304/316 SS sheet 26 ga (0.018" thick)	
		Batch: <u>109398</u> <u>1B 8-12-15</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3650	
		Dwg Rev: <u>C</u> <u>1B 8-12-15</u> Prog Rev: <u>C</u>	(8)
		2-Deburr if necessary	<u>1B 8-12-15</u> (8)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>1B 8-12-15</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>S 08/12/17</u> (8)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: Bend as per dwg D3650	<u>S 08/12/17</u> (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 43820

Part Number: D365011

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/12/17 X8

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: ST115

808/12/17 X8

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/18 X8

Job Completion



MF 08-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

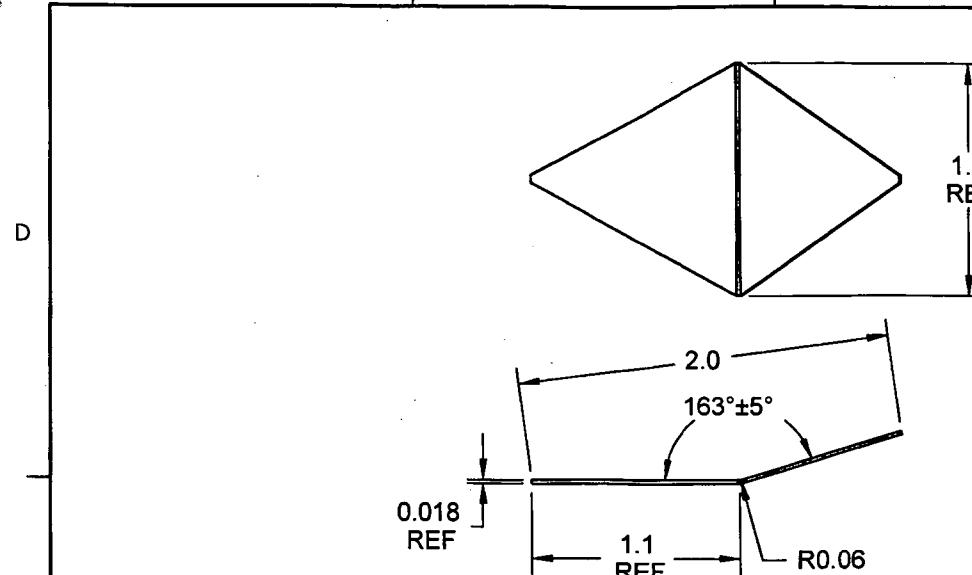
DART AEROSPACE LTD	Work Order:	43820
Description: Filler Plate	Part Number:	D3650-11
Inspection Dwg: D3650 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

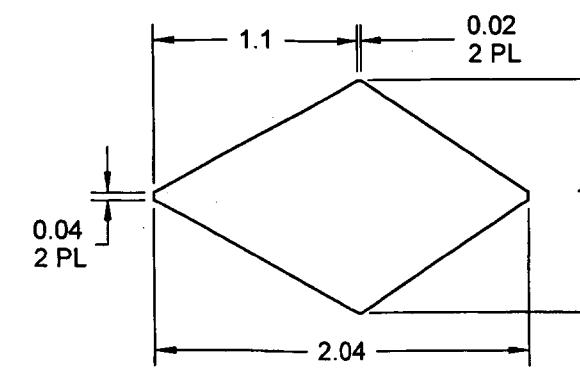
X First Article Prototype

Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	08-12-24	Date:	08/12/17	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	08.07.24	New Issue	KJ/DD		

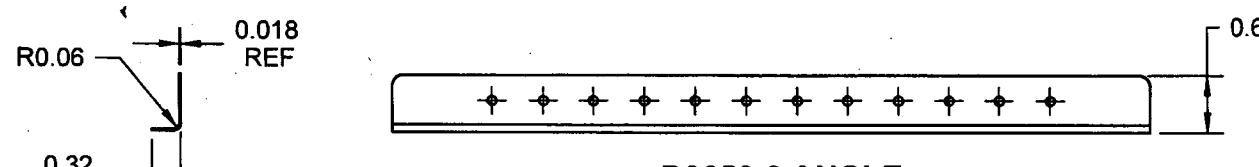
8 7 6 5 4 3 2 1



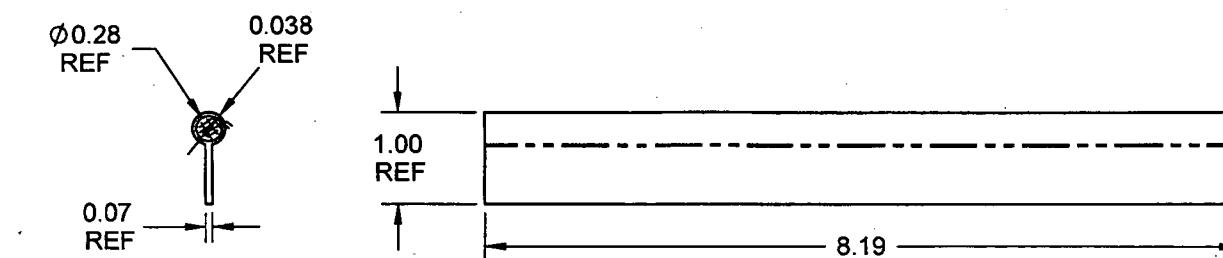
**D3650-11 FILLER PLATE
(MAKE FROM D3650-11F FLAT PATTERN)**



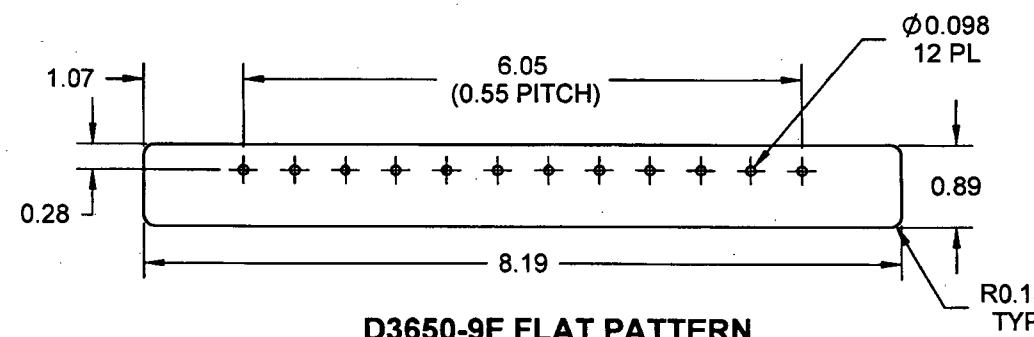
D3650-11F FLAT PATTERN



**D3650-9 ANGLE
(MAKE FROM D3650-9F FLAT PATTERN)**



D3650-7-8.19 SEAL



D3650-9F FLAT PATTERN

D3650-7-8.19 NOTES:

- 1) MATERIAL: P/N 8168-1 TADPOLE SEAL (REF. BELL P/N 120-104-1)
POSSIBLE SUPPLIER: EAGLE COPTERS OR BELL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lb
- 8) PART NUMBER: D3650-7-X.XX
WHERE X.XX = LENGTH IN INCHES
EG. 12.50" LONG = D3650-7-12.50

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 43820

RELEASED
08/11/17 MJW

D3650-9 & D3650-11 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET,
PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
CHECKED	B	DRAWING NO.			
MFG. APPR.		REV. C			
APPROVED		D3650			
DE APPR.		SHEET 9 OF 9			
DATE	08.10.14	TITLE			
		TOP PANEL ASSEMBLY			
		SCALE			
		NTS			
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